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PURPOSE: To obtain an automatic grinder for rolling mills, which minimizes the influence of chattering by automatically increasing or decreasing gradually the rotating speed of a work in accordance with the traverse of a grindstone, the rotation of the work, or working time.

CONSTITUTION: The standard rotating speed of a work 1 is set on a standard rotating speed section 7. When an end sensor 11a is actuated, a function generator 6 is reset so that the rate of increase and decrease becomes zero and the work 1 rotates at the standard rotating speed when the grindstone starts its traversing motion. When the grindstone moves from the left end to the right and sensors 9aW9g are actuated, the function generator 6 goes into action to increase or decrease the speed command signal 8 from the standard rotating speed setting 7, thus controlling the rotating speed of the work. This minimizes the influence of chattering if it occurs during the grinding operation.

